



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4149-041
Job Sheet 190558



Part No: D4149-041

Job Qty: 5 pcs

Part Name: Aft Crosstube Lug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP
Rev:C 11.03.03 as per revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	5 Ea	3/4/19	3/4/19	0.00	0.00	Start Up Small Fab-3			DAS 58 9-89 MAY 03 2019
100	Small Fab - 1	5 pcs	3/4/19	3/4/19	0.00	1.25	Small Fab - 1			
105	Small Fab - 2 - B4B	5 pcs	3/4/19	3/4/19	0.00	1.25	Small Fab - 1 - B4B			
							Small Fab - 2 - B4B			DAS 58 9-89 MAY 03 2019
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
110	QC 5	5 pcs	3/4/19	3/4/19	0.00	0.00	QC 5 - 10			DAS 40 9-89 MAY 03 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
120	Packaging 3-1 - Stock - B4B	5 pcs	3/4/19	3/4/19	0.00	0.00	Packaging 3 - 1 - B4B			
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			
							Packaging 3 - 4 - B4B			

					Packaging 3 - 5 - B4B					
					Packaging 3 - 6 - B4B					
					Packaging 3 - 7 - B4B					
					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B	Pc MAY 06 2019 51539				
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					130 QC 21 - SA	5 pcs	3/4/19	0.00 0.00	QC 21 - SA - 21	DAS
									QC 21 - SA - 70	21
									QC 21 - SA - 53	9-89

Part Op 110 - (QC5- Inspect part completeness to step on W/O)
 Descriptions: 120 - (Identify as per dwg & Stock Location: _____)
 130 - (QC21- Final Inspection - Work Order Release)

MAY 06 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	10 Ea (2 ea)	90-Start up Operation	
AN4C13A	Bolt	15 Ea (3 ea)	90-Start up Operation	
D3910-1	Crosstube Lug	5 pcs (1 ea)	90-Start up Operation	
D4091-1	Mounting Lug	5 pcs (1 ea)	90-Start up Operation	
D4149-1	Crosstube Lug Plate, Aft	10 pcs (2 ea)	90-Start up Operation	
D4149-3	Spacer	5 pcs (1 ea)	90-Start up Operation	
D4149-5	Eyebolt Stud	5 pcs (1 ea)	90-Start up Operation	
MS20615-4M18	Rivet	15 Ea (3 ea)	90-Start up Operation	
MS21043-3	Nut	10 Ea (2 ea)	90-Start up Operation	
MS21043-4	Nut	15 Ea (3 ea)	90-Start up Operation	
NAS1149C0332R	Washer	20 Ea (4 ea)	90-Start up Operation	
NAS1149C0432R	Washer	30 Ea (6 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	10	177	0
	AN4C13A	15	182	0
	D3910-1	5	70	0
	D4091-1	5	53	0
	D4149-1	10	33	0
	D4149-3	5	39	0
	D4149-5	5	31	0
	MS20615-4M18	15	294	0
	MS21043-3	10	1,196	0
	MS21043-4	15	1,278	0
	NAS1149C0332R	20	5,307	0
	NAS1149C0432R	30	1,586	0
Part Specifications				
Specifications could not be found.				

Plex 5/2/19 4:36 PM Dart.Hadley.Shannon



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Part Weight: 0 lbs

Status: New

Priority: Medium

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	5 Ea	3/4/19	3/4/19	0.00	0.00	Start Up Small Fab-3			58 9-89
100	Small Fab	5 pcs	3/4/19	3/4/19	0.00	1.25	Small Fab-6			58 9-89
110	QC	5 pcs	3/4/19	3/4/19	0.00	0.00	QC5			
120	Packaging	5 pcs	3/4/19	3/4/19	0.00	0.00	Packaging3-2			
130	QC21-SA	5 Ea	3/4/19	3/4/19	0.00	0.00	QC21			

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	10 Ea (2 ea)	90-Start up Operation	5149192
AN4C13A	Bolt	15 Ea (3 ea)	90-Start up Operation	5152509
D3910-1	Crosstube Lug	5 pcs (1 ea)	90-Start up Operation	5174260
D4091-1	Mounting Lug	5 pcs (1 ea)	90-Start up Operation	5153696
D4149-1	Crosstube Lug Plate, Aft	10 Ea (2 ea)	90-Start up Operation	5170665
D4149-3	Spacer	5 pcs (1 ea)	90-Start up Operation	5176718
D4149-5	Eyebolt Stud	5 pcs (1 ea)	90-Start up Operation	5182228
MS20615-4M18	Rivet	15 Ea (3 ea)	90-Start up Operation	5160790
MS21043-3	Nut	10 Ea (2 ea)	90-Start up Operation	5149144
MS21043-4	Nut	15 Ea (3 ea)	90-Start up Operation	5173785
NAS1149C0332R	Washer	20 Ea (4 ea)	90-Start up Operation	5143145
NAS1149C0432R	Washer	30 Ea (6 ea)	90-Start up Operation	5103990

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	10	129	0
	AN4C13A	15	115	0
	D3910-1	5	61	0
	D4091-1	5	38	0
	D4149-1	10	1	0
	D4149-3	5	6	0
	D4149-5	5	30	0
	MS20615-4M18	15	218	0
	MS21043-3	10	1,382	0
	MS21043-4	15	1,538	0
	NAS1149C0332R	20	4,726	0
	NAS1149C0432R	30	1,469	0

Part Specifications

Specifications could not be found.

Plex 2/11/19 12:47 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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www.dartaerospace.com

Container No: S177508



Part: D4149-041

Job No: 190558

Serial No/Batch: S177508

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/02/19